

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011763**Date Inspected:** 02-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 5E green tag #2. The weld designations reviewed are as follows:

5AE

1. OBE5A-004

7AW+7BW

Submerged Arc Welding (SAW) welding on weld joint 003 located at OBW7 deck plate weld seam.

Welder is identified as Mrs. Ma Ying (045270). ZPMC QC is identified as Gu Rongjian. The welding variables recorded by QC appeared to comply with WPS-B-T-223(2)1T-2.

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Submerged Arc Welding (SAW) welding on weld joint 003 located at OBW7 deck plate weld seam. Welder is identified as Mrs. Zhou Dianqin (250050). ZPMC QC is identified as Gu Rongjian. The welding variables recorded by QC appeared to comply with WPS-B-T-223(2)1T-2.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 007 located at OBW7 counter weight of segment. Welder is identified as Mr. Wang Guijun (067279). ZPMC QC is identified as Gu Rongjian. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

### 6CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 032 located at SEG029B on cross beam side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Gu Rongjian. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and WR 10467 repair procedure.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at CA029 on counter weight side of segment. Welder is identified as Mr. Zhao Bing (067764). ZPMC QC is identified as Gu Rongjian. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at CA031 on cross beam side of segment. Welder is identified as Mr. Jiang Zhen (068917). ZPMC QC is identified as Gu Rongjian. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

### 7AW

Flux Core Arc Welding (FCAW) welding was performed on weld joints 05 and 06 located at SEG029B on cross beam side of segment. Welder is identified as Mr. Dong Changxi (070046). ZPMC QC is identified as Gu Rongjian. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2132.

### 6CW+6BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBW6C on counter weight side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Gu Rongjian. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-Repair-1 and WR 10479 repair procedure.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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